

4130 3/4

## Work Order ID 109408

\*109408\*

Page 1

November-21-13 2:14:53 PM

Item ID: D3059-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Stud

Start Date: 11/21/13 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 11/21/13 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-11-25 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3059	Rev A1								
100	BAND SAW	0.00							
*100*	Memo	0.00							
Bandsaw	Turn blank as per Folio FA400 and Dwg D3059Cut groove as per Folio FA400								
Jeaspa Bandsaw	and Dwg D3059Identify as D3059-1Deburr and Tumble for a short time to								
	prevent damage to threads								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*	Memo	0.00							
QC									
Quality Control									
*115	Haas 1 (mill slot)								
120	QC8- Inspect parts - second check	0.00							
*120*	Memo	0.00							
QC									
Quality Control									

F.K. 13/12/17

10

Ø

JFL 2015-12-02

F.K. 13/12/17

10

Ø

JFL 2015-12-02

J. 13-12-20

10

Ø

J.A. 13/12/20

10

Ø

DAS  
08  
9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 109408

November-21-13 2:14:53 PM

\*109408\*

Page 2

Item ID: D3059-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Stud

Start Date: 11/21/13

Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 11/21/13

Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00

\*130\*

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 22577 Finish: Cadmium plate per QQ-P-416F Class 1,  
Type II Material release note is required.

CL 14/01/10 (10)

140

0.00

\*140\*

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.00

Packaging

Ensure Material Release Note is attached Identify and Stock Location: 57024

12/14/13 (10)

150

0.00

\*150\*

QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10X DAS 28 14-01-24  
9-89

(14-01-24)

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

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# Picklist Print

November-21-13 2:14:53 PM

Page 1

Work Order ID: 109408

Parent Item: D3059-1

Parent Item Name: Stud

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A04.03.25New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NR0.750 4130 steel RD bar .750"		Purchased	No			100	f	8.7160	0.1666	1.753684			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT031	8.716	
111823	1.648	
123772	7.068	

\* 127753

1.5' Fk 73/12/17

Could not pull mat!!

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

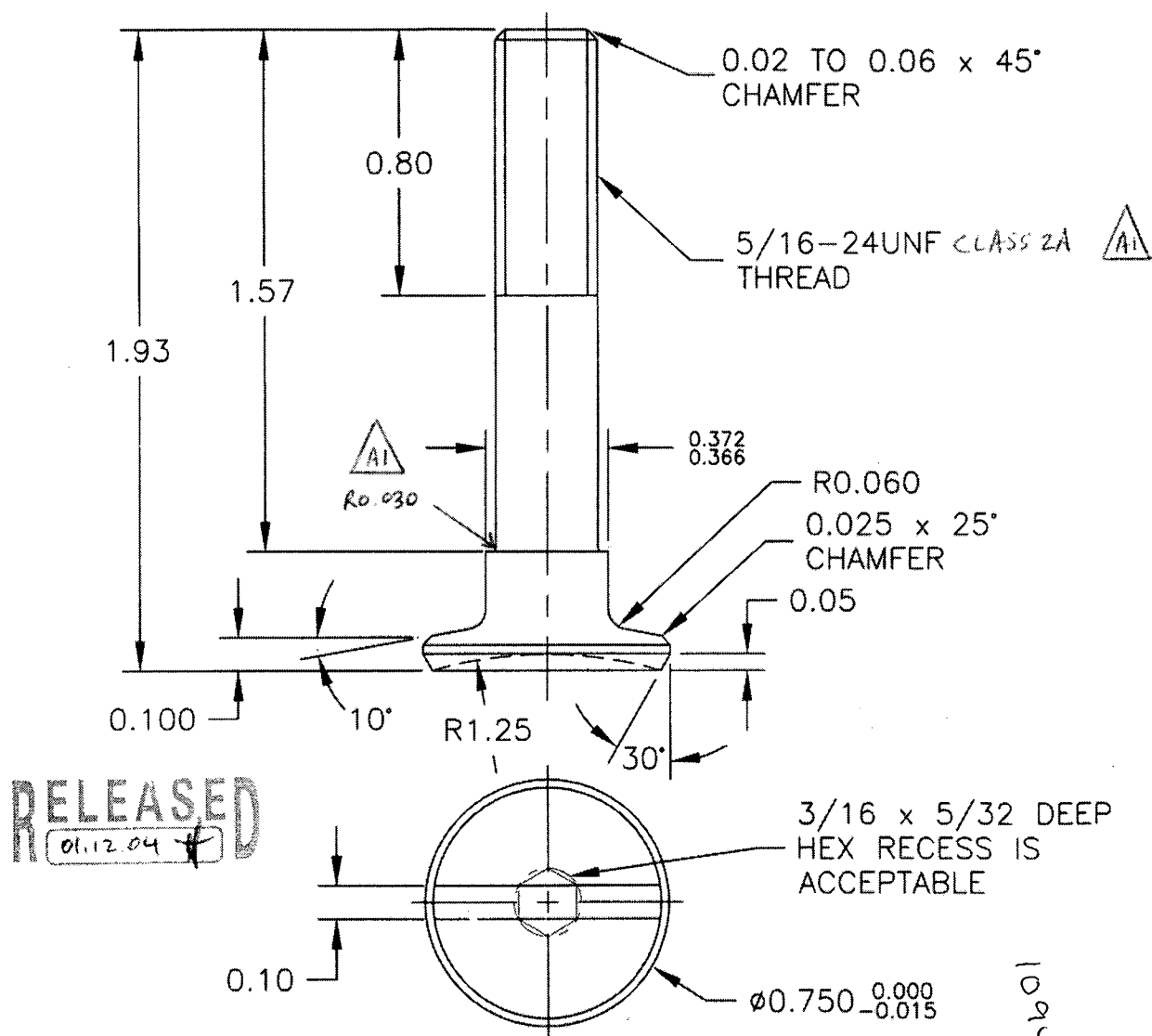
### FAULT CATEGORY

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DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3059	REV. A SHEET 1 OF 1
DATE 01.11.27		TITLE STUD	SCALE 2:1
A	01.11.27	NEW ISSUE	
A1	#UP 01.04.01	ADD R0.030 & CLASS 2A	

## SPECIFICATION CONTROL DRAWING



D3059-1:

- 1) POSSIBLE SUPPLIER: ANCRA INTERNATIONAL P/N 40110-10
- 2) MATERIAL: AISI 4130N BAR PER MIL-S-6758 OR AMS 6348/6370/6528  
MIN TENSILE STRENGTH 180 KSI
- 3) THREADS PER MIL-S-7742
- 4) FINISH: CADMIUM PLATE PER QQ-P-416F CLASS 1, TYPE II
- 5) ALL DIMENSIONS ARE IN INCHES.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

109408 MCS  
13-11-25

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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 109408
<b>Description:</b> Stud -	<b>Part Number:</b> D3059-1
<b>Inspection Dwg:</b> D3059-1 Rev: A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.80	+/- .030	.80	✓		FK-04	Vern -
1.57	+/- .030	1.572	✓		"	"
1.93	+/- .030	1.925	✓		"	"
.100	+/- .010	.101	✓		"	"
10°	+/- .5°	10°	✓		A-G	
.05	+/- .030	.040	✓		FK-04	Vern -
.025 x 25°	+/- .010	.025 x 25°	✓		"	"
R .06	+/- .030	.06	✓		R-G	
372 - .360		.369	✓		FK-04	Vern -
<del>5/16-24 UNF</del>	<del>N/A</del>					
.02 - .06 x 45°		.04	✓		FK-04	Vern -
.750	+ .000 / - .015	.745	✓		"	"
.10	+/- .030					
R 1.25						
Major Dia.	Min: .3042 Max: .3114	.310	✓		FK-04	Mic
Minor Dia.	Min: .3315 Max: .3352	.3338	✓		"	"
Haas 1						
.10	+/- .030	.0965	✓		SL08	Vern
.05	+/- .030	.049	✓		"	"

<b>Measured by:</b> FR	<b>Audited by:</b> J.A. DA	<b>Preliminary Approval:</b>
<b>Date:</b> 13/12/17	<b>Date:</b> 13/12/20 <sup>08</sup>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO22577

Purchase Order Date 1/10/2014

PO Print Date 1/14/2014

Page Number 1 of 1

**Order From :**

CADORATH COATING  
2150 LOGAN AVE.  
WINNIPEG, MB R2R 0J2  
CA

VC-CAD002

**Ship To :** DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**Contact Name**

**Vendor Phone** 204 633 9420

**Buyer**

Chantal Lavoie

**Customer POID**

**Customer Tax #**

10127-2607

**Terms**

Net 30

**Currency**

CAD

**FOB**

Destination-Collect

**Ship To Contact**

**Ship To Phone**

**Ship Via:** FedEx PI collect

**Ship Acct:**

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	109929	D3028-1 STUD	1/24/2014 Yes 1/24/2014		20.00	\$10.50	\$210.00
	FINISH: CADMIUM PLATE PER QQ-P-416F CLASS 1, TYPE II						
						<b>Line Total:</b>	<b>\$210.00</b>
2	109408	D3059-1 STUD	1/24/2014 Yes 1/24/2014		10.00	\$10.50	\$105.00
	FINISH: CADMIUM PLATE PER QQ-P-416F CLASS 1, TYPE II						
						<b>Line Total:</b>	<b>\$105.00</b>
						<b>PO Total:</b>	<b>\$315.00</b>

**Note:** Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.  
No substitution or deviation without consent.  
Certificate of Conformity or Material Certification required - YES NO  
PST# 6122-5207

Change Nbr:

2

Change Date: 1/14/2014

# Packing Slip



## Cadorath Coating

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2

Phone: (204) 633-9420 Fax: (204) 633-8033

**INVOICE NUMBER:**

**S 69311**

**Sold To:**

Dart Aerospace Ltd.  
1270 Aberdeen St.

Hawksbury, ON K6A 1K7

**ShipTo:**

Net 2% Interest Per Month charged on Overdue Accounts.

Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

Customer Order #:	Date Received:	Terms:	G.S.T. #:	Ship Via:	Ship Date:
PO22577	Jan-14-2014	NET 30 DAYS	10071 6547 RT0001		Jan-22-2014

Item # Qty P/N & Description

1	20 EA	STUD	S/N 109929
		P/N D3028-1	W/O 131758
2	10 EA	STUD	S/N 109408
		P/N D3059-1	W/O 131759

**CERTIFICATE OF  
CONFORMANCE**

**CADORATH PLATING CO. LTD.  
2150 LOGAN AVENUE  
WINNIPEG, MANITOBA R2J-0J1**

**DATE:** Jan-22-2014

**CONSIGNED TO:** Dart Aerospace Ltd.  
1270 Aberdeen St.  
Hawksbury, ON K6A 1K7

**W/O #:** 131759

**INVOICE #:** 69311

**CONTRACT OR  
PURCHASE ORDER # PO22577**

**DESCRIPTION:** STUD

**QTY** 10

**P/N #** D3059-1

**S/N #** 109408

**CADMIUM PLATING IAW AMS-QQ-P-416C TYPE 2 YELLOW CLASS 1.  
BAKE HEAT CHART # 14-60.**

**CERTIFICATE: I certify that the items indicated here on have  
been inspected and tested and conform to all specifications  
and requirements detailed on the contract or purchase order.**



**Approved Inspector:**

A handwritten signature in black ink, consisting of a series of loops and a long horizontal stroke.